	r ID 97336 5 15, 2013 9:10:53 AM		*973	36*	i		5	ip!	to day	Page	1
Revision ID: Item Name:	D3183-045  Bearing Assembly 2/15/2013 Start Qty: 12.00 2/15/2013 Req'd Qty: 12.00	*12*	1 /			100	<b>)*</b> s	etup Star	1/1	S1* S2*	<u> </u>
Approvals:	Process Plan: NWF  QC:	Date: 13-2-15 Date:	Tooling: SPC (Y/N):		Date: Date:		R	Run Stari Stop	I <i>Л</i>	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr					Couc	Qiy	- Qty		Stamp	
D3183	Rev C1									SB	
*130 *130* Small Fab Small Fab	Small Fab  Memo Press D318	33-5 Bearing into D3183-9 Cap	0.00 0.00 o as per Dwg D3183.				10.			131	tōz
140 *140* QC Quality Control	QC5- Inspect part comp	oleteness to step on W/O	0.00 PAS 0.00 PS 2	15			10	· · · · · · · · · · · · · · · · · · ·			
*150 *150* Packaging Packaging	Identify as per dwg & S <b>Memo</b>	Stock Location:	0.00				JE,	13/4	16	(10)	-

NCR:	Yes /	No	WORK ORDER NON-CO
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DQA:	Date	:	
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NCR: Ye	es / No				WORK ORDER NON-	CONF	DR۸	ANCE / UPDAT	TE	•		٤
										QA Closed:	Date	:
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Part No					Rework Scrap Use-as-is	- - - - -	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing				d. Eng. Coor. re/Packaging	Quality Other
NCR N	0				Work Order Update	_   _		Large Fab Co	omposite		Supplier	
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initi Chief	- E	Action Description	ţ	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						FAULT C						
Landin					General	FAULIC	AIE	JORT				
Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Ha Ins Ins Mi Mi Off	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	<b>⊣</b>	Sequence wist in Tul		-	Finish Folio	<del>     </del>		Sequence Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97336 Friday, February 15, 2013 9:10:53 AM Item ID: D3183-045 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Bearing Assembly **Start Date: Start Qty: 12.00** 2/15/2013 **Cust Item ID:** Required Date: 2/15/2013 Req'd Qty: 12.00 **Customer:** Reference: Start Run Approvals: **Process Plan:** Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject

**Run Hours** 

0.00

0.00

Work Center ID

\*160\*

Quality Control

160

QC

Description

QC21- Final Inspection - Work Order Release

Memo

MC5 13-02-15 MF (3-2-15

Number Stamp

Code

Qty

Qty

Insp.

Page 2

											DQA:	Date:		
NCR:	/es	/ No				WORK ORDER NON-	CON	NFORM	ANCE / UP	DATE	•		7	
		,							·		QA Closed:	Date:		
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					· · ·	Use-as-is		Therm	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	۱o.					Work Order Update			Large Fab	Composite	J	Supplier		
Root					Descri	iption of work order update		nitial	Ac	tion	Sign &			
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	┢	Cracks	or conce	intine to	<sup>5/3</sup>  -	Broken/Damaged		•	on incomplete	-	Part Incorre	<u> </u>	Weld	
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	$\vdash$	Cuffs	camped.	•	-	Contamination		Mainte		-	Part Moved			
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	H	4		Tube		Cut Too Short		┩					Other	
	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes									L	10.000			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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## Picklist Print

Friday, February 15, 2013 9:10:53 AM

Work Order ID:

97336

Parent Item:

D3183-045

Parent Item Name:

Bearing Assembly

**Start Date: 2/15/2013** 

Required Date: 2/15/2013

Start Qty: 12.00

Required Qty: 12.00

Comments:	IPP A04.02.18No	ew issueKJ/DS											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>D3183-9</b> Cap		Manufactured	No				Each	50.0000		12		(3	102/15
				<b>Location</b>		Loc Qty	Lo	oc Code					
				FG		5				<del> </del>			
				8949	92	5							
				ST235		45				;			
				9638	30	45							
D3183-5 Bearing		Manufactured	No			110	Each	32.0000	1	12		SB 13	102/15
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10

92224

NCR: Y	'es	/ No				WORK ORDER NON-O	CON	<b>IFORN</b>	AANCE / UP	DATE			*
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NCR N	lo.		·-·	<u></u>	·	Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Rec/Store/Packaging Other Supplier			
Root					Descri	iption of work order update	Ti	nitial	Ac	tion	Sign &		
Cause	1	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	
		  Inspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	'Surge	Other
		Ripples in	•			Drill Holes		Offset			=		
	Torque Waves in Extrusion					Drawing		Out of	Calibration				
		Turning S				Finish		Out of S	Sequence				
Wave/Twist in Tube						Folio		Outside	Dimensions				

DQA:

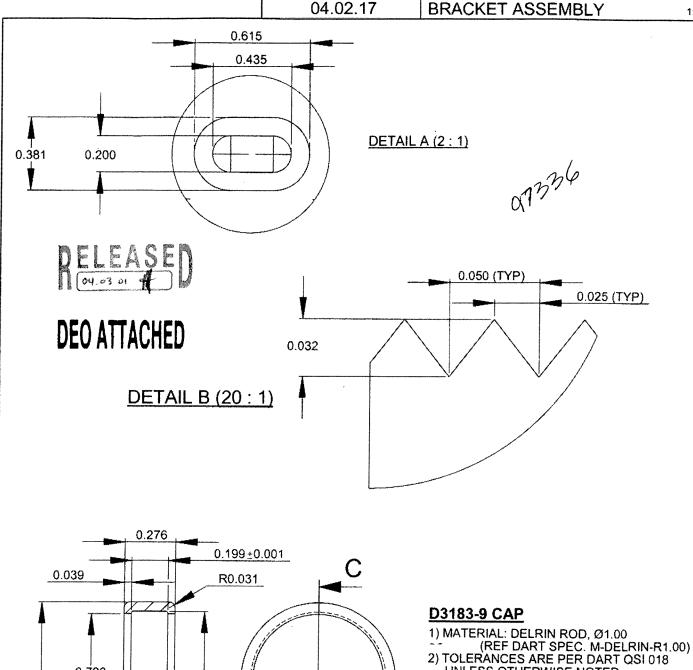
Date:





DESIGN	DRAWN BY	DART AERC HAWKESBURY, C	SPACE LTD  ONTARIO, CANADA
 CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE	·	TITLE	SCALE

1:1



## 0.720 -0.850±0.002 0.747 0.830 ±0.001 /c/ R0.010 **SECTION C-C** SCALE 2:1

- UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

## D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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		Cuffs				_	Contamination	-	Mainte	<b>⊢</b>	Part Moved		
	Heat Treat						Countersink	-	Mislabe	<b>}</b> −	Positioned \	_	Jothan
	Inspection Strip in Tube						Cut Too Short	$\vdash$	Misread	, <u> </u>	Power Loss,	Surge	Other
ļ		Ripples in		*v+m.ic:+	_ }		Drill Holes	$\vdash$	Offset	Calibration			
		Torque W			" }	_	Drawing Finish	$\vdash$	4	Calibration Sequence			
		Turning So	equence		1		FIIII5(I	1	TOUT OF:	bequence			

Outside Dimensions

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Wave/Twist in Tube

Folio